

Work Order ID 68115

Wednesday, April 06, 2011 2:58:58 PM



Page 1

Item ID: D2844-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm

Start Date: 4/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 11-04-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2844	Rev A

100 0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Form per Dwg D2844 using brake and bending Jig DT 8238-B ☐ Debur

⇒ m-l 11/04/11

(6X)

110 0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

11.04.12 (6)

120 0.00



White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Powdercoat

Memo

0.00

Powder Coating

START TIME: 3:15 ☐ OVEN TEMPERATURE:

7:00 ☐ FINISH TIME: 3:45

6 BR 11-4-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 6 11/04/12

140

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

11 04 14 6

150

Identify as per dwg & Stock Location: 5205

0.00



Packaging

Memo

0.00

Packaging

5/14/14 6

W/O:		WORK ORDER CHANGES					
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Page 3

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Accept

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Item Name: Arm

Start Date: 4/6/2011 Start Qty: 6.00

Required Date: 4/12/2011 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/15 [Signature]
1104-14
[Signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 06, 2011 2:59:04 PM

Page 1

Work Order ID: 68115

Parent Item: D2844-1

Parent Item Name: Arm




Start Date: 4/6/2011

Required Date: 4/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B000.11.01 Removed P/O for Powder Coat - in house process EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035  304 RD Tube .500 x .035W		Purchased	No			100	f	35.2900	1.8991	11.99432			

m-h 4/04/11

Location

Loc Qty

Loc Code

MAT017

35.29

115535

10

115990 ✓

5.29

116720 ✓

20

11.99432

W/O:		WORK ORDER CHANGES					
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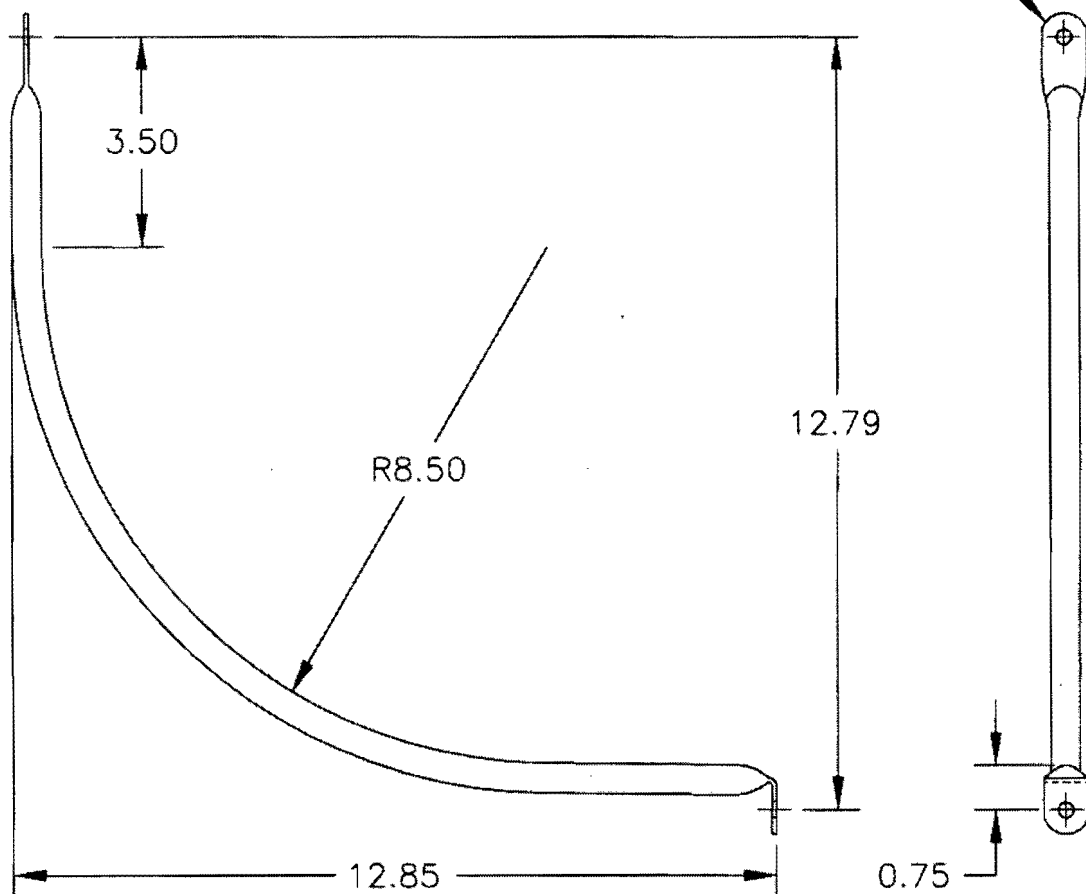


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAH</i>	APPROVED <i>CS</i>	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED
98.11.11 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *68115*

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



PL 11-04-9

D2844-1

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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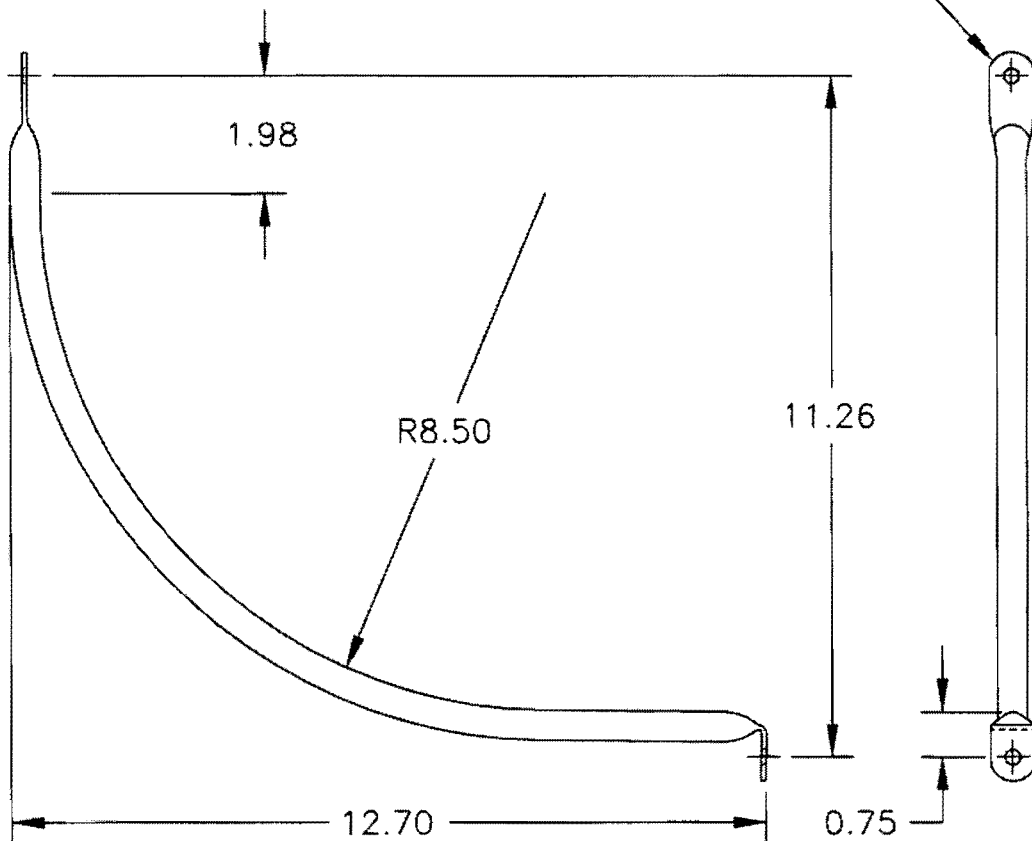


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14	TITLE ARM		SCALE 1:3

RELEASED
18.11.11 KE

also 68115

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-3

MATERIAL: AISI 304/316 SS TUBE, $\phi 0.50 \times 0.035$ WALL
ENSURE TUBE IS SEAMLESS
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

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